

Work Order ID 161699***161699***

Page 1

Tuesday, May 23, 2017 9:31:00 AM

Item ID: D206-718-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fuel Scupper
Start Date: 5/30/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 6/2/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **MAY 23 2017** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-718	A								

100 Document Control 0.00
100 DOCUMENT CONTROL
DC Memo 0.00
Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPPD206-718-011 CHG001

4X **DAS 27 9-89**
JUN 12 2017

110 Pick Kit 0.00
110
Packaging Memo 0.00
Packaging

XY **DAS 28 9-89**
JUN 12 2017

120 QC4- 100% Inspect kits for completeness 0.00
120
QC Memo 0.12
Quality Control

XY **DAS 27 9-89**
JUN 12 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 161699

Tuesday, May 23, 2017 9:31:00 AM

161699

Page 2

Item ID: D206-718-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Scupper

Start Date: 5/30/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/2/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging	Identify as per dwg & Stock Location: _____ Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-718-011 Location : <u>FG124</u>								
140 *140* QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.40							

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JUN 12 2017DAS
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9-89
JUN 12 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	OTHER :							
Misidentified	☐	Past Due								

Picklist Print

Tuesday, May 23, 2017 9:30:59 AM

Page 1

Work Order ID: 161699

161699

Parent Item: D206-718-011

D206-718-011

Parent Item Name: Fuel Scupper

Start Date: 5/30/2017

Required Date: 6/2/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: C Removed manufacturing 05-11-01

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
80-004-2-12 *80-004-2-12* Insert		Purchased	No			110	Each	16.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>					
				ST585				16					
				m134370				7					
				m135895				9					
AN3H14A *AN3H14A* Bolt		Purchased	No			110	Each	99.0000	4	16			
				<u>Location</u>				<u>Loc Qty</u>					
				ST349				99					
				120423				99					
D3270-041 *D3270-041* Fuel Scupper Assembly		Manufactured	No			110	Each	7.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>					
				ST028				7					
				145186				2					
				156807				2					
				159534				3					
D3271-1 *D3271-1* Gasket		Manufactured	No			110	Each	16.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>					
				ST029				16					
				141998				16					

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JUN 09 2017

DAS
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JUN 09 2017

DAS
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9-89

DAS
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9-89

DAS
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JUN 09 2017

DAS
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DAS
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JUN 09 2017

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9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			OTHER : ☐																	

Picklist Print

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Page 2

Work Order ID: 161699

161699

Parent Item: D206-718-011

D206-718-011

Parent Item Name: Fuel Scupper

Start Date: 5/30/2017

Required Date: 6/2/2017

Start Qty: 4.00

Required Qty: 4.00

MS21919-DF6 MS21919WDF6 Purchased No

110 Each 10.0000 1 4

MS21919-DF6

Clamp

**

JUN 09 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

ST292

10

m135297

10

MS27039-1-40 Purchased No

110 Each 44.0000 1 4

MS27039-1-40

Screw

**

JUN 09 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

ST279

44

m134574

44

NAS1149D0332 Purchased No

110 Each 1,366.000 1 4

NAS1149D0332.I

Washer

**

JUN 09 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

FP

241

m136015

8

m137075

233

GA

332

m136643

332

ST264

793

m136015

0

m137412

793

NAS43DD3-128 Purchased No

110 Each 13.0000 1 4

NAS43DD3-128

Spacer

**

JUN 09 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

ST550

13

m134055

3

m136866

10

DAS 27 9-89

Tuesday, May 23, 2017 9:30:59 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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		OTHER : ☐																							

DART

DESIGN #	DRAWN BY A	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D206-718	REV. A SHEET 1 OF 1
DATE 04.02.23		TITLE FUEL SCUPPER	SCALE NTS
A	04.02.23	NEW ISSUE	

REFERENCE ONLY

Qty -011	Part No.	Description
X	D206-718-011	FUEL SCUPPER
1	D3270-041	FUEL SCUPPER ASSEMBLY (REPLACES ECM 32801-01)
1	D3271-1	GASKET (REPLACES ECM 32801-05)
1	80-004-2-12	INSERT
4	AN3H14A	BOLT
1	AN960JD10L	WASHER
1	MS21919DF6	CLAMP
1	MS27039-1-40	SCREW
1	NAS43DD3-128	SPACER

GENERAL NOTES:

- 1) D206-718-011 REPLACES ECM 206-99216-1
- 2) INSTALL D206-718-011 KIT PER INST32801-04 REV. 0 (REF: DOCUMENT CONTROL LIST A-328-DCL1 REV. 0 PER CANADIAN STC SH99-216 & FAA STC SR01187NY)

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Work Order ID 161699

Tuesday, May 23, 2017 9:31:00 AM

161699

Page 1

Item ID: D206-718-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Fuel Scupper

Stop ***NS2***

Start Date: 5/30/2017 Start Qty: 4.00

4

Required Date: 6/2/2017 Req'd Qty: 4.00

4

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan:

Date: **MAY 23 2017**

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
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Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D206-718

A

MAY 31 2017

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPPD206-718-011 CHG001

CB

4 JUN 01 2017

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.12

Quality Control



Department of Transport

Supplemental Type Certificate

This approval is issued to:

Eagle Copters Ltd.
823 McTavish Road N.E.
Calgary
Alberta T2E-7G9

Approval Number: SH99-216

Issue Number: 1

Date of Approval: 1999 October 01

Date of Issue: 1999 October 01

Responsible Office: Prairie and Northern

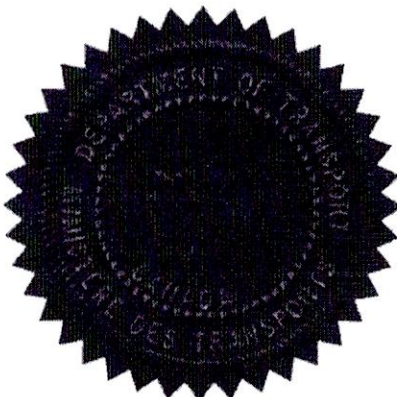
Aircraft/Engine Type/Model: Bell 206A, 206B

**Canadian Type Certificate or
Equivalent:** H-92/H2SW

Description of Design Change: Fuel Scupper Drain Assembly Installation in lieu of Bell part 206-072-911-101.

**Installation/Operating Data,
Required Equipment and
Limitations:** Installation of the fuel scupper drain assembly shall be done in accordance with the Installation Documents of Transport Canada approved Document Control List A-328-DCL1, Rev 0, dated 22 March 1999.

Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated will not adversely affect the airworthiness of the modified product.



F.J.B. Wright

For Minister of Transport